

AD712305

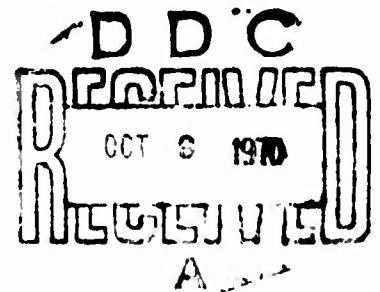
AMMRC TR 70-15

AD

CERAMIC WEAR-RESISTANT COATING FOR ALUMINUM - PHASE I

WILLIAM D. LONG
CERAMICS DIVISION

July 1970



This document has been approved for public release and sale; its distribution is unlimited.

ARMY MATERIALS AND MECHANICS RESEARCH CENTER
Watertown, Massachusetts 02172

Reproduced by the
CLEARINGHOUSE
for Federal Scientific & Technical
Information Springfield Va 22151

ADDITIONAL		
OPEN		
ABC		
CHANGING		
JUSTIFICATION		
BY		
DISPOSITION/AVAILABILITY CODES		
DET.	AVAIL.	CODE/W SPECIAL

The findings in this report are not to be construed as an official Department of the Army position, unless so designated by other authorized documents.

Mention of any trade names or manufacturers in this report shall not be construed as advertising nor as an official indorsement or approval of such products or companies by the United States Government.

DISPOSITION INSTRUCTIONS

Destroy this report when it is no longer needed.
Do not return it to the originator.

AMMRC TR 70-15

CERAMIC WEAR-RESISTANT COATING FOR ALUMINUM - PHASE I

Technical Report by

WILLIAM D. LONG, 1LT, Ord C

July 1970

D/A Project 1T062105A330

AMCMS Code Number 502E.11.296

Ceramic Materials Research for Army Materiel

Agency Accession Number DA OB4806

This document has been approved for public release and sale; its distribution is unlimited.

CERAMICS DIVISION

ARMY MATERIALS AND MECHANICS RESEARCH CENTER

Watertown, Massachusetts 02172

ARMY MATERIALS AND MECHANICS RESEARCH CENTER

CERAMIC WEAR-RESISTANT COATING FOR ALUMINUM - PHASE I

ABSTRACT

Initial wear test results for flame-sprayed, plasma-sprayed, and slurry-coated 6061-T6 aluminum alloy samples are reported. Optical photomicrographs of coating cross-sections are also presented. Upon final evaluation of these coatings in Phase II of the program, one will be chosen for Phase III scale-up for a coating on aluminum track shoes.

CONTENTS

	Page
ABSTRACT	
INTRODUCTION	1
PROCEDURE	1
RESULTS AND DISCUSSION	3
CONCLUSIONS	6
ACKNOWLEDGMENTS	6
APPENDIX A	7
LITERATURE CITED	12

INTRODUCTION

This study was begun as the first step in the development of wear-resistant aluminum components suitable to replace hardened steel parts currently in use. The program was aimed primarily at the development of track shoes since this was considered to be one of the most severe environments in which aluminum could be used.

The program was divided into three phases. Material test coupons were purchased and evaluated during Phase I. Further coupon testing and initial coated track shoe testing will be conducted in Phase II. Phase III will provide for the production scale-up of the best coating selected on the basis of the results of the first two phases. The program is a joint effort by AMMRC and ATAC with the AMMRC Ceramics Division having primary responsibility for the conduct of Phase I and II and with the ATAC Materials Engineering Branch assuming primary responsibility in Phase III. This report is intended to summarize the results obtained during Phase I.

PROCEDURE

Coatings were applied by contractors to 6061-T6 aluminum alloy by three different techniques, consisting of several different materials for each technique. The following is a list of these techniques and the materials that were evaluated for each:

1. Flame spray

- a. aluminum oxide - titanium dioxide
- b. nickel-chrome-aluminum
- c. nickel-chrome-boron
- d. tungsten carbide
- e. molybdenum
- f. aluminum

2. Plasma spray

- a. aluminum oxide-aluminum (graded)
- b. titanium dioxide-aluminum (graded)

3. Viscous slurry

- a. aluminum oxide-aluminum (1:10)
- b. aluminum oxide-aluminum (1:5)
- c. aluminum oxide-aluminum (1:3)
- d. aluminum oxide-aluminum (1:2)
- e. aluminum oxide-aluminum (1:1)
- f. silicic acid-aluminum (1:10)
- g. silicic acid-aluminum (1:5)
- h. silicic acid-aluminum (1:1)
- i. silicic acid-aluminum (2:1)
- j. silicic acid-aluminum (5:1)

- k. chromium carbide-aluminum (1:1)
- l. chromium carbide-aluminum (1:2)
- m. chromium carbide-aluminum (1:3)
- n. chromium carbide-aluminum (1:5)
- o. chromium carbide-aluminum (1:10)
- p. aluminum oxide (small particle)-aluminum (graded)
- q. aluminum oxide (large particle)-aluminum (graded)

The graded, plasma-sprayed coatings were applied by proprietary modifications* to standard plasma spray application techniques.^{1,2,3,4} The flame-sprayed coatings were applied by standard techniques,⁵ however, a proprietary interlayer† was sandwiched between the aluminum substrate and the final exterior coating. A general discussion of all molten particle spray techniques is also available.⁶ The viscous slurry coatings, of which detailed compositions and processing techniques‡ are proprietary, are painted on the aluminum substrate surface. Subsequent heat treatments and additional slurry applications result in a densified coating that is bonded to the aluminum.

Wear testing for initial screening of the coatings was performed on a Taber Abraser wear testing machine (Figure 1), utilizing standard helix-edged tungsten carbide abrasion wheels (Figure 2) under a 500-gram load. It was considered that these wheels would impart shear as well as compressive stresses to the coatings.

Optical photomicrographs were taken of each of the coatings evaluated in this phase of the program. Typical examples are presented, with composition identification information in Appendix A.

A specimen of each of the coatings was subjected to the following thermal treatments. Specimens were placed in a furnace at room temperature. The temperature was gradually raised to a 970 F soak temperature and held for one hour.

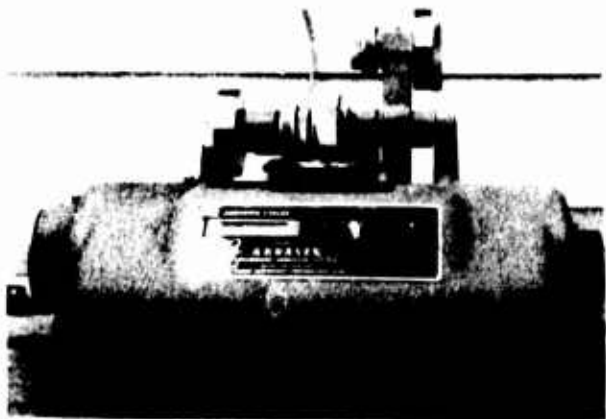


Figure 1. TABER ABRASER WEAR TEST MACHINE
19-066-487/AMC-68



Figure 2. TUNGSTEN CARBIDE HELIX-
EDGED ABRASION WHEELS
19-066-257/AMC-70

*Proprietary to Monsanto Research Center, Dayton, Ohio.

†Proprietary to Metalcraft, Inc., Norfolk, Virginia.

‡Proprietary to Kaman Nuclear, Colorado Springs, Colorado.

After the soak period, the specimens were water-quenched to room temperature. Specimens were again placed in the furnace at room temperature, heated at 350 F, soaked for one hour, and then air cooled. It was considered that this thermal cycle would simulate the most severe strengthening cycle for any of the aluminum alloys considered for use as track shoes.

RESULTS AND DISCUSSION

The wear test results obtained in Phase I are summarized in Table I. Typical wear patterns for the coatings applied by flame spraying, plasma spraying, and slurry coating are evident in Figures 3, 4, and 5. Only the plasma-sprayed coatings were adversely affected by the thermal treatment. The coating warpage and crazing that resulted from the treatment on the plasma-sprayed coatings is noted in Figures 4 and 6. The crazing is particularly severe in the case of the titanium dioxide coating (Figure 6). It should be noted that although the flame-sprayed coatings were not detrimentally affected by this treatment, they were only one-fifth the thickness (0.005" as compared to 0.025") of the coatings applied by the plasma spray or the slurry techniques. This alone would tend to make them more thermal shock resistant. It should also be noted that further

Table I. WEAR TEST RESULTS UTILIZING TABER ABRASER
FITTED WITH TUNGSTEN CARBIDE WHEELS

Application Technique	Material Applied	Total Weight Loss (in grams) After:		
		1,000 cycles	5,000 cycles	10,000 cycles
Flame spray	Al ₂ O ₃ - TiO ₂	0.0882	0.1367	0.1514
Slurry	SiO ₂ - Al (2:1)	0.0218	0.0865	0.1636
Flame spray	Ni - Cr - Al	0.0903	0.1385	0.1742
Plasma spray	TiO ₂ (graded)*	0.0575	0.1414	0.1931
Slurry	SiO ₂ - Al (1:1)	0.0481	0.1425	0.2286
Flame spray	Tungsten carbide	0.1229	0.1947	0.2512
Plasma spray	Al ₂ O ₃ (graded)*	0.0981	0.2518	0.2770
Plasma spray	TiO ₂ (graded)	0.3004	0.3442	0.3783
Slurry	Cr ₂ C - Al (1:3)	0.1052	0.2673	0.3976
Slurry	Al ₂ O ₃ - Al (1:3)	0.1441	0.3008	0.4012
Slurry	SiO ₂ - Al (1:3)	0.1102	0.2785	0.4062
Slurry	Al ₂ O ₃ - Al (1:5)	0.1976	0.3662	0.4701
Slurry	Al ₂ O ₃ - Al (1:2)	0.2028	0.3889	0.5266
Slurry	SiO ₂ - Al (1:10)	0.2116	0.4417	0.5733
Slurry	Cr ₂ C - Al (1:5)	0.1907	0.4244	0.6039
Slurry	Cr ₂ C - Al (1:10)	0.2816	0.4909	0.6441
Slurry	Al ₂ O ₃ - Al (1:10)	0.2907	0.5885	0.7555
Flame spray	Molybdenum	0.2614	0.5331	0.7607
Plasma spray	Al ₂ O ₃ (graded)	0.3836	0.6468	0.8296
Flame spray	Ni - Cr - B	0.3230	1.1416	-
Flame spray	Aluminum	1.4919	4.1069	-

*Thermal treatment before wear test.



Figure 3. FLAME-SPRAYED $\text{Al}_2\text{O}_3\text{-TiO}_2$
COATING AFTER WEAR TESTING
19-066-256/AMC-70

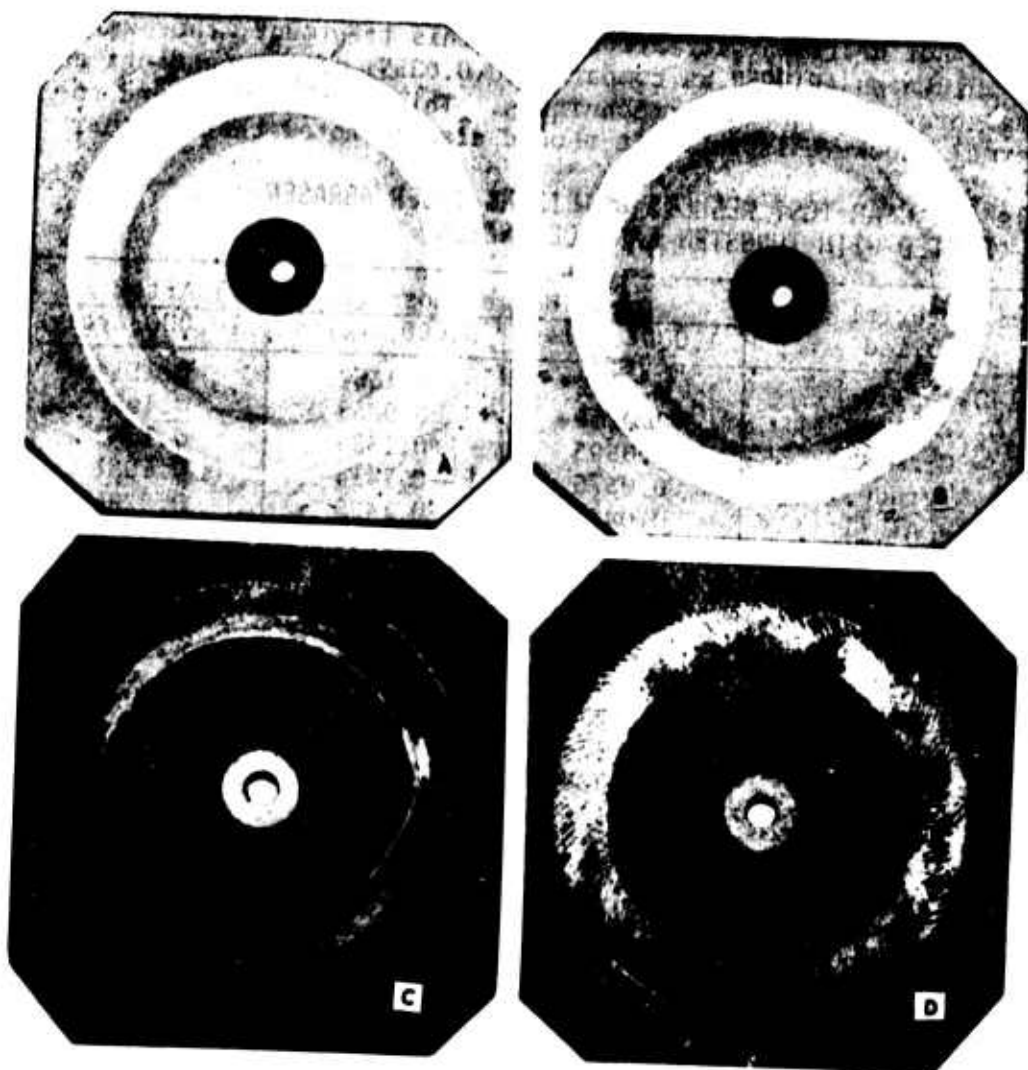
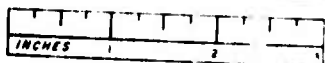


Figure 4. PLASMA-SPRAYED COATINGS AFTER WEAR TESTING

- 19-066-254/AMC-70
- | | |
|--|---|
| A. Al_2O_3 without thermal treatment | C. TiO_2 without thermal treatment |
| B. Al_2O_3 with thermal treatment | D. TiO_2 with thermal treatment |

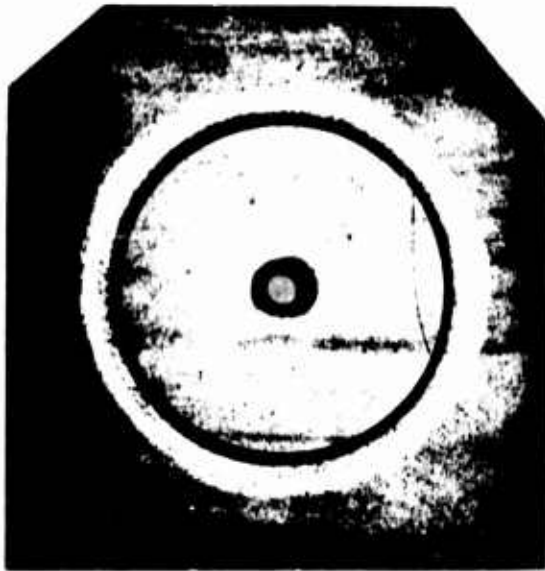


Figure 5. SLURRY-APPLIED $\text{SiO}_2\text{-Al}$ (2:1)
COATING AFTER WEAR TESTING
19-066-253/AMC-70

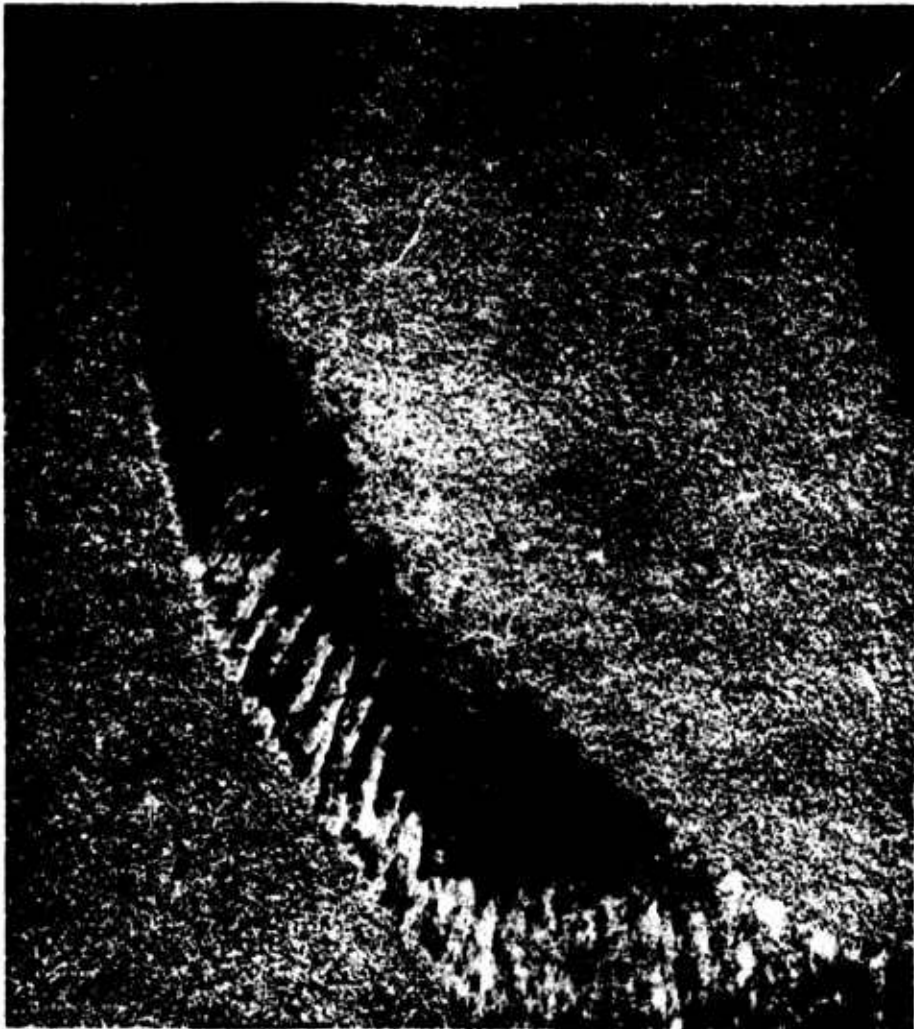


Figure 6. CRAZING OF PLASMA-SPRAYED TiO_2 COATING AFTER WEAR TESTING. Mag. $3\frac{1}{2}\times$
19-066-258/AMC-70

1

wear testing of the samples at up to 30,000 cycles could give a totally different comparative wear scale than that presented in Table I. The longer test duration may cause the thinner coatings, that presently are most wear resistant, to break down, in which case the thicker plasma-sprayed and slurry-applied coatings would prove more favorable.

CONCLUSIONS

The results for Phase I of this program, although enlightening, clearly show the necessity for the Phase II testing before the Phase III scale-up can be considered. The thinner flame-sprayed coatings which are superior at this stage of the wear testing may prove inferior to the other thicker plasma-sprayed and slurry-coated specimens when additional testing, to be conducted in Phase II, is completed.

Pull test data to determine bonding strengths of the coatings should also be included in Phase II. Although the coatings will not be subjected to tensile stress, as it is applied in this test, a measure of bonding strengths should prove valuable, especially if coupled with an impact test. An abrasion test, utilizing an abrasive grit-blasting technique to obtain a wear resistance measurement, may provide valuable information. Hard and soft anodized aluminum specimens should also be included in the wear testing program as controls.

In Phase II the effect of the heat generated by plasma spraying on the strength of the base aluminum should be determined. If it does not degrade the strength, the coating would not have to be subjected to the thermal cycle used to strengthen the aluminum base. It was this thermal cycle that caused the warpage and crazing, with subsequent loss of bond strength. If it can be eliminated, a harder and denser plasma-sprayed coating could be applied, thus improving the wear resistance.

ACKNOWLEDGMENTS

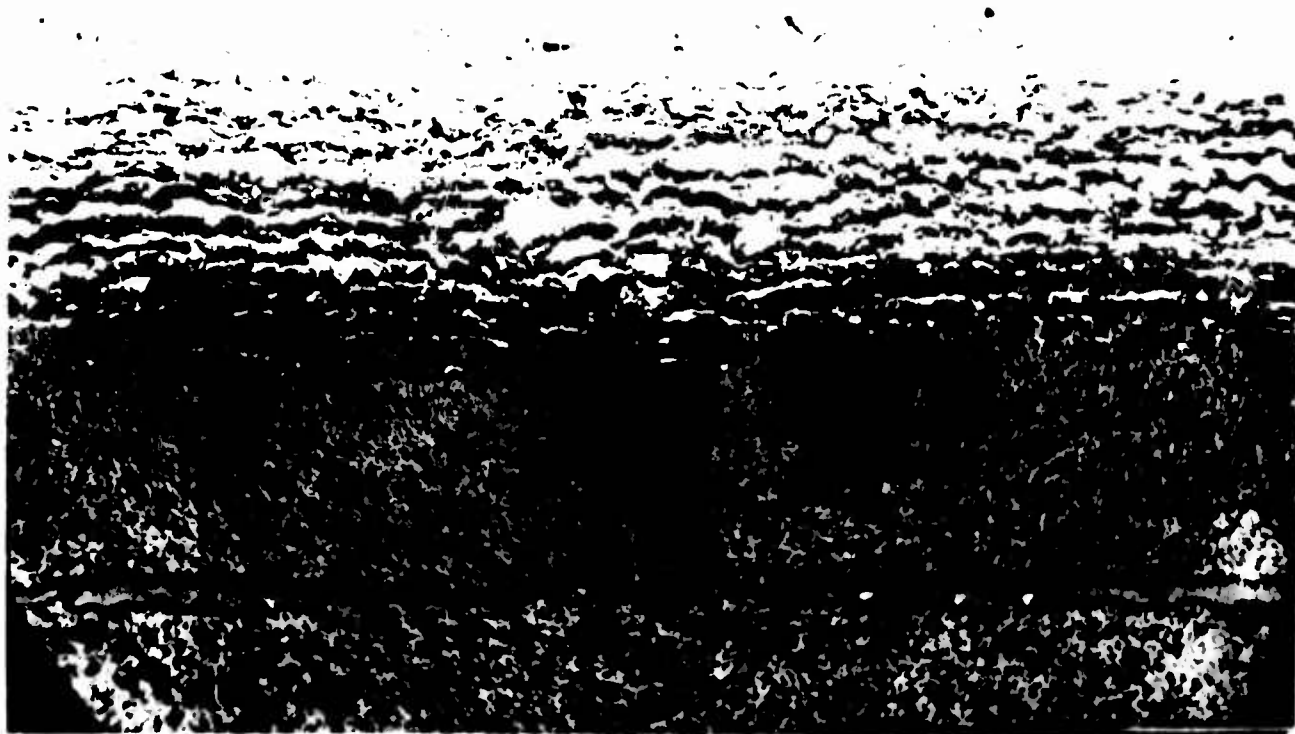
The author expresses gratitude to S. Nanfria for the excellent photographs included in this report. The efforts of J. Morrossi who performed the wear testing are greatly appreciated. The author is particularly grateful to S. Acquaviva and F. Meyer for their prompt critical review of this report.

APPENDIX A

Photomicrographs of typical flame-sprayed, plasma-sprayed, and slurry-coated 6061-T6 aluminum samples tested in Phase I of the program. Micrographs were taken of the cross-section of each of the samples at the magnifications indicated. Other materials applied by each of the processing techniques possessed, respectively, similar appearances to those shown in Figures A-1 to A-3.



Figure A-1. FLAME-SPRAYED $\text{Al}_2\text{O}_3\text{-TiO}_2$. Mag. 1000X



a. Overall Cross-Section. Mag. 50X



b. Al_2O_3 Rich Side of Graded Region Mag 1000X

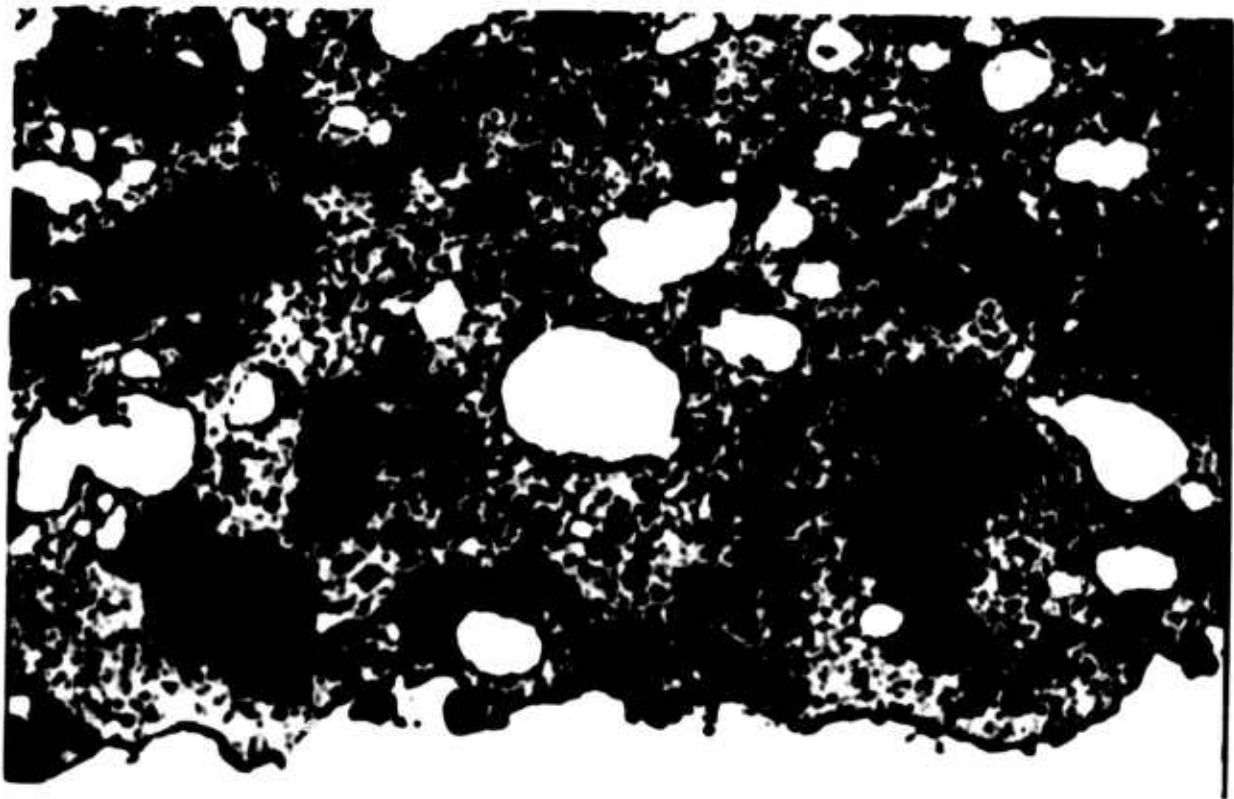


c. Aluminum-Rich Side of Graded Region. Mag. 1000X
(black, porosity; white, aluminum; gray, alumina)

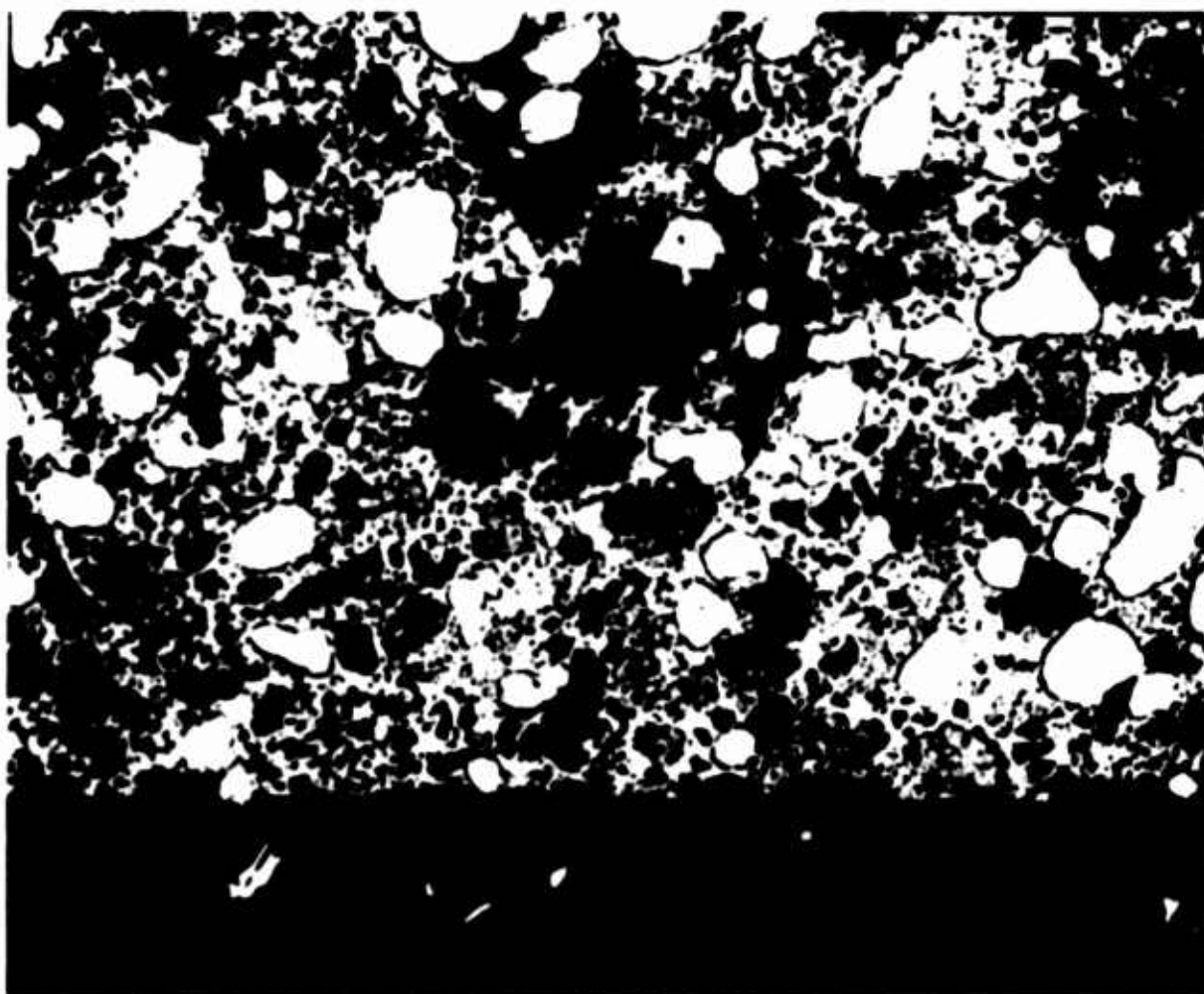
Figure A-2. PLASMA-SPRAYED GRADED Al_2O_3



a. Overall Cross-Section. Mag. 100X



b. Coating Substrate Interface Mag 500X



c. Region Near Coating Surface. Mag. 500X
(black, porosity; mottled white, aluminum; solid white, SiO_2 ; mottled gray, bonding agent)

Figure A-3. SLURRY-COATED SiO_2 -Al (2:1)

LITERATURE CITED

1. ORBACH, H. K. *How Ceramics Uses Plasma-Jet*. Ceramic Industry, November 1962, p. 72-75
2. LEEDS, D. H. *Interface Bonding Studies and a New Plasma Arc Spray Gun - Accomplishments and Plans*. Presented at the Refractories Composites Working Group Meeting sponsored by NASA-WADD, 8-10 August 1961.
3. LEVINSTEIN, M. A. *Properties of Plasma Sprayed Materials*. Aeronautical Systems Division, Air Force Systems Command, Wright Paterson Air Force Base, Ohio, technical documentary report no. ASD-TDR-62-201, June 1962.
4. METCO, INC. *The Plasma Flame Spray Process*. Bulletin No. 142F, 1966.
5. METCO, INC. *Thermo-Sprayed Process*. Bulletin No. 153, 1968.
6. COMMITTEE ON CERAMIC PROCESSING, MATERIALS ADVISORY BOARD, DIVISION OF ENGINEERING, NATIONAL RESEARCH COUNCIL. *Ceramic Processing*. National Academy of Sciences, Washington, D. C., Publication No. 1576, 1968, p. 105-112.

UNCLASSIFIED

Security Classification

DOCUMENT CONTROL DATA - R & D

(Security classification of title, body of abstract and indexing annotation must be entered when the overall report is classified)

1. ORIGINATING ACTIVITY (Corporate author) Army Materials and Mechanics Research Center Watertown, Massachusetts 02172		2a. REPORT SECURITY CLASSIFICATION Unclassified	
		2b. GROUP	
3. REPORT TITLE CERAMIC WEAR-RESISTANT COATING FOR ALUMINUM - PHASE I			
4. DESCRIPTIVE NOTES (Type of report and inclusive dates)			
5. AUTHOR(S) (First name, middle initial, last name) William D. Long			
6. REPORT DATE July 1970		7a. TOTAL NO. OF PAGES 13	7b. NO. OF REFS 6
8a. CONTRACT OR GRANT NO.		9a. ORIGINATOR'S REPORT NUMBER(S)	
b. PROJECT NO D/A 1T062105A330		AMMRC TR 70-15	
c. AMCMS Code 502E.11.296		9b. OTHER REPORT NO(S) (Any other numbers that may be assigned this report)	
d. Agency Accession Number DA OA4806			
10. DISTRIBUTION STATEMENT This document has been approved for public release and sale; its distribution is unlimited.			
11. SUPPLEMENTARY NOTES		12. SPONSORING MILITARY ACTIVITY U. S. Army Materiel Command Washington, D. C. 20315	
13. ABSTRACT Initial wear test results for flame-sprayed, plasma-sprayed, and slurry-coated 6061-T6 aluminum alloy samples are reported. Optical photomicrographs of coating cross-sections are also presented. Upon final evaluation of these coatings in Phase II of the program, one will be chosen for Phase III scale-up for a coating on aluminum track shoes. (Author)			

DD FORM 1473

REPLACES DD FORM 1473, 1 JAN 64, WHICH IS OBSOLETE FOR ARMY USE.

UNCLASSIFIED
Security Classification

UNCLASSIFIED

Security Classification

KEY WORDS	LINK A		LINK B		LINK C	
	ROLE	WT	ROLE	WT	ROLE	WT
Ceramic coatings Wear tests Plasma spraying Flame spraying Sprayed coatings Abrasion resistant coatings Densification						

UNCLASSIFIED

Security Classification